



Dart Aerospace Ltd.
1270 Aberdeen St
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Canada

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D3502-1
Job Sheet 197735



Part No: D3502-1

Job Qty: 16 pcs

Part Name: Support



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/16/19

Job Tracking No:

Due Date: 8/30/19

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV B IPP Rev:A New Issue 06-07-06 JLM IPP Rev:B Add tooling hole 07-03-28 Esr rev C added
DT9430 08.11.03 EC verified by:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	16 pcs		8/30/19	0.00	0.63	Bandsaw - 1		SBL 19/07/30
110	HAAS 4 Axis - B4B	16 pcs		8/30/19	0.16	5.35	HAAS - 1 - B4B		
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		SBL 19/07/30
							HAAS - 4 - B4B		
130	QC 8	16 pcs		8/30/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		



Container No: S201774



Part: D3502-1

Job No: 197735

Serial No/Batch: S201774

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
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Date: 07/30/19

140 Small Fab - 2 - B4B	16 pcs	8/30/19	0.00 0.49	Small Fab - 1 - B4B	smf 19/11/14
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	
				Small Fab - 6 - B4B	
				Small Fab - 7 - B4B	
150 Handfinish - 1-1 Chemical-B4B	16 pcs	8/30/19	0.00 0.27	Handfinish - 1 - 1 - B4B	AUG 16 2019
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
160 Powdercoat - 1 White G(A)-B4B M193454	16 pcs	8/30/19	0.00 0.25	Powdercoat - 1 - B4B	BR 19-8-20..
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
170 QC 3 STAKI 845 OUT. 320°F IN. 9.15.	16 pcs	8/30/19	0.00 0.00	QC 3 - 10	
				QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	

					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
180	Packaging 3-1 - Stock - B4B	16 pcs	8/30/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	NL LG52
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
190	QC 21 - SA	16 pcs	8/30/19	0.00 0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

DAG
46
AUG 21 2019 9-89

NL LG52

DAG
21
9-89
AUG 22 2019

Part Op **100** - Cut blank 3.475 " long 1 BLANK MAKES 2 PARTS
 Descriptions: **110** - 1- Mill as per Folio FA649 Rev: 44 & Dwg D3502 Rev: B 2-Deburr per dwg D3502
130 - (QC8- Inspect parts - second chec
140 - Mark hole position using DT9430 Drill as per Dwg D3502.
150 - (Chemical Conversion Coat per QSI005 4.1)
160 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____

170 - (QC3- Inspect Part Finish)
 180 - Identify as per dwg & Stock LOCATION : LG052
 190 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X04.000	6061-T6 Bar 1.00 X 4.00	2.3120 ft (.1445 ea)	100-Bandsaw - 1	5150 545

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B1.000X04.000	2	47	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Support	1.590inches $\pm$ 0.010	1.600 1.580	1,590	
2	Support	1.177inches + 0.005 - 0.000	1.182 1.177	1,778	
3	Support	0.130inches $\pm$ 0.010	0.140 0.120	0,130	
4	Support	0.080inches $\pm$ 0.010	0.090 0.070	1080	
5	Support	0.928inches $\pm$ 0.010	0.938 0.918	926	
6	Support	0.100inches $\pm$ 0.010	0.110 0.090	099	
7	Support	0.100inches $\pm$ 0.010	0.110 0.090	099	
8	Support	1.390inches $\pm$ 0.030	1.420 1.360	1,394	

Plex 7/16/19 8:17 AM dart.lacelle.linda